Working Instruction, Standard

Applicable for R320s, R320sc

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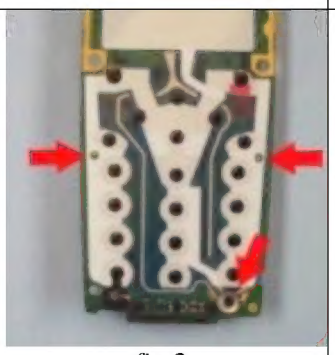
1 Domeswitch

Important about soldering operation!

When any kind of soldering operations is done on the back of PCB or near the domeswitch it must be removed and replaced with a new one

#	Figure	Instruction	Note
1		Domeswitch replacement	
2	*fig.1*	Remove the old domeswitch with a pair of tweezers *(fig.1)*.	
3		Brush/Clean the board surface.	
4		Take a new domeswitch	
5	 *fig.2*	Place the new domeswitch on the board, use the guiding holes and the connection point for the EL-lamp for correct positioning *(fig.2)*.	Make sure that the domeswitch is correct assembled and that the washer is right positioned.

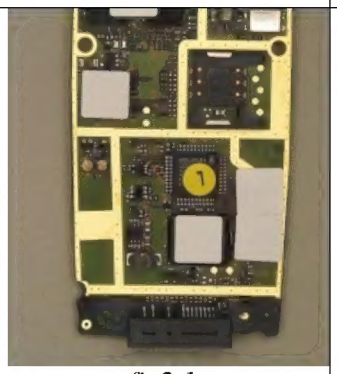
2 Frame Assembly

2.1 Process Tools

- Hotmelt glue gun.
- Tweezers.

2.2 Instruction

- Dismount the phone as described in Mechanical Instructions 3/00021-1/FEA 209 544/21 (Disassembly).

#	Figure	Instruction	Note
1	*fig2.1*	Remove the vibrator assembly from the old frame. (fig 2.1).	
2		Take a new frame assembly.	
3		Mount the old vibrator assembly the RF-gasket in the frame.	
4	 *fig2.1*	Mount marking labels on the three µBGA components (fig2.2).	Don't cover the grounding surface on the board with the labels.
5		Apply three glue spheres on the paper labels with a diameter about 3-5mm.	Exchange the elastomeric connector etc. before you start working with the glue.

- Mount the phone as described in Mechanical Instructions 3/00021-1/FEA 209 544/21 (Reassembly).

3 Revision History

Rev.	Date	Changes / Comments
B	2000-03-10	Chapter 2 added